

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017831**Date Inspected:** 08-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 11DW and Seg 11EW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW11A-006 [Edge Panel (EP) to EP – W1 side; transverse splice complete joint penetration (CJP) weld]. The welder is identified as 040611 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS):

B-P-2213-B-U2-FCM-1.

OBG Seg 11DW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SP745-001-049 [T-rib to Side Panel (SP) – hold back fillet weld – W4 side, at PP107]. The welder is identified as 049220 and was observed welding in the 2F

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position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no: SP507-001-056 (T-rib to SP – hold back fillet weld – W4 side, at PP107). The welder is identified as 053486 and was observed welding in the 2F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 11EW:

The FCAW process on weld joint no: SP746-001-001 (T-rib to SP – hold back fillet weld – W4 side, at PP107). The welder is identified as 049220 and was observed welding in the 2F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no: SP508-001-056 (T-rib to SP – hold back fillet weld – W4 side, at PP107). The welder is identified as 053486 and was observed welding in the 2F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 11CE and Seg 11DE:

The SMAW process on weld joint no: OBE11C-003 [Bottom Panel (BP) to BP; transverse splice CJP weld]. The welders are identified as 040484 and 053871 and were observed welding in the 4G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The FCAW process on weld joint no: SP716-001-031 (T-rib stiffener; CJP weld, E1 side). The welder is identified as 047353 and was observed welding in the 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-B-U2-F.

The SMAW process on weld joint no: OBE11A-003 [Deck Panel (DP) to DP – transverse splice CJP weld]. The welder is identified as 067752 and was observed welding in the 4G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 11BE and Seg 11CE:

This QA Inspector observed ABF personnel doing Ultrasonic Testing (UT) of weld joint nos: OBE11B-008 (BP-BP, transverse splice CJP weld) and OBE11B-009 and 010 (SP-SP; transverse splice CJP weld).

This QA Inspector observed ZPMC personnel doing heat straightening of T-rib stiffener; CJP weld- SP381-046, at Panel Point (PP) 101. Heat straightening was done as per heat straightening report (HSR): 9807. ZPMC QC was identified as An Qing Xiang. See attached photo for further details.

OBG Seg 11BW and Seg 11CW:

This QA Inspector observed ABF personnel doing Magnetic Particle Testing (MT) of hold back fillet welds on

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bottom panel of Seg 11BW and Seg 11CW. ZPMC QC was identified as Zhou Peng. See attached photo for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Dsouza,Christopher	QA Reviewer

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